

Work Order ID 54292

Page 1

December 7, 2009 2:30:44 PM

Item ID: D412-769-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seats (LH/RH)

Start Date: 07/12/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-769	Rev B

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

Photocopy bluefile & type labels per PPP D412-769-011 CHG 001

S 10/01/25

110



QC4- 100% Inspect kits for completeness

0.00

0.00

=> S 10/01/25

QC

Quality Control

Memo

(X5)

120



Packaging

0.00

Memo

0.00

Packaging

Packaging

Identify and pack for shipping as per PPP D412-769-011 Location: _____ PPP Rev: C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54292

Page 2

December 7, 2009 2:30:44 PM

Item ID: D412-769-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seats (LH/RH)

Start Date: 07/12/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
					Stop
	QC:	Date:	SPC (Y/N):	Date:	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00							<i>10/01/25</i>
QC	Memo	0.00							

Quality Control

MF 10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 1

December 7, 2009 2:30:48 PM

Work Order ID: 54292



Parent Item: D412-769-011



Parent Item Name: Aft Facing Seats (LH/RH)

Start Date: 07/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D412-769-041		Manufactured	No			110	Each	0.0000	5.0000		54292	
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Aft Facing Seat, LH

D412-769-042

Aft Facing Seat, LH		Manufactured	No			110	Each	0.0000	5.0000		54292	6/1/12005
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Aft Facing Seat, RH

S5

S5

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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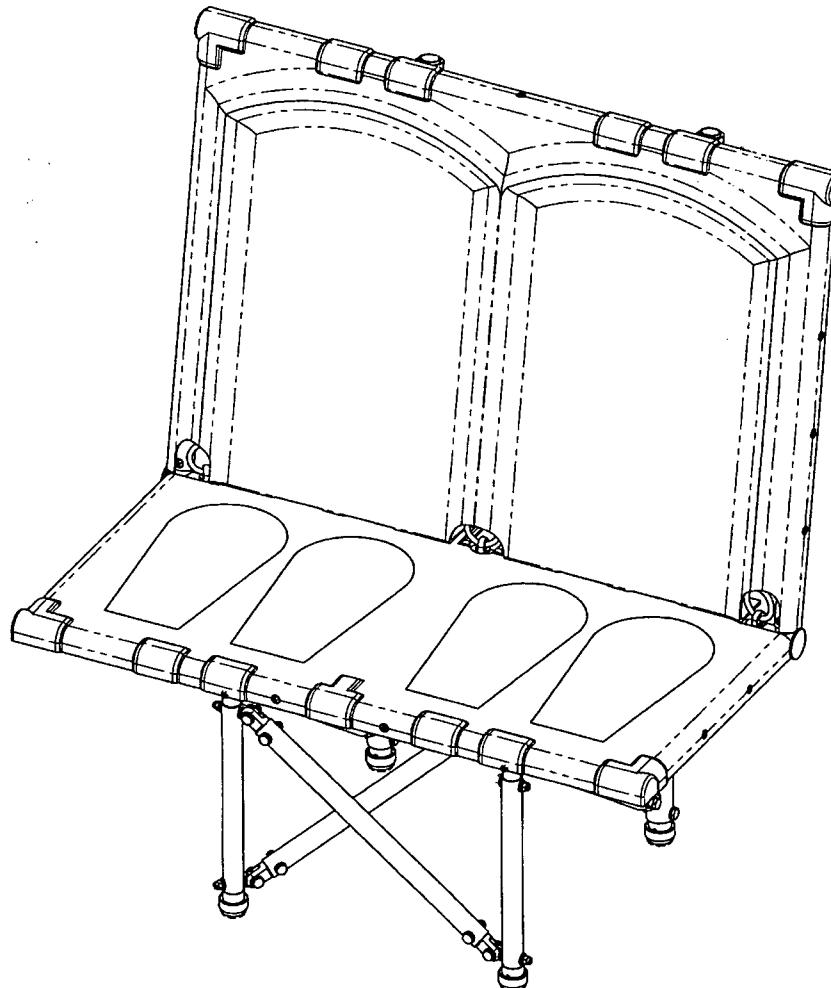
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D412-769-043 AFT FACING SEAT ASSY, LH

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 RETURNED
 ENCL NO.
 UNCOPIED COPY
 MTO CLEARED
 V.A.L. 10/07/04
 V.A.L. 10/07/04
 NO. 54292
 BY 09127

RELEASED
 58-07-09 1400

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	AA	D412-769-1	SHEET 1 OF 7
APPROVED	NP	TITLE	SCALE
DE APPR.	NP	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS EXRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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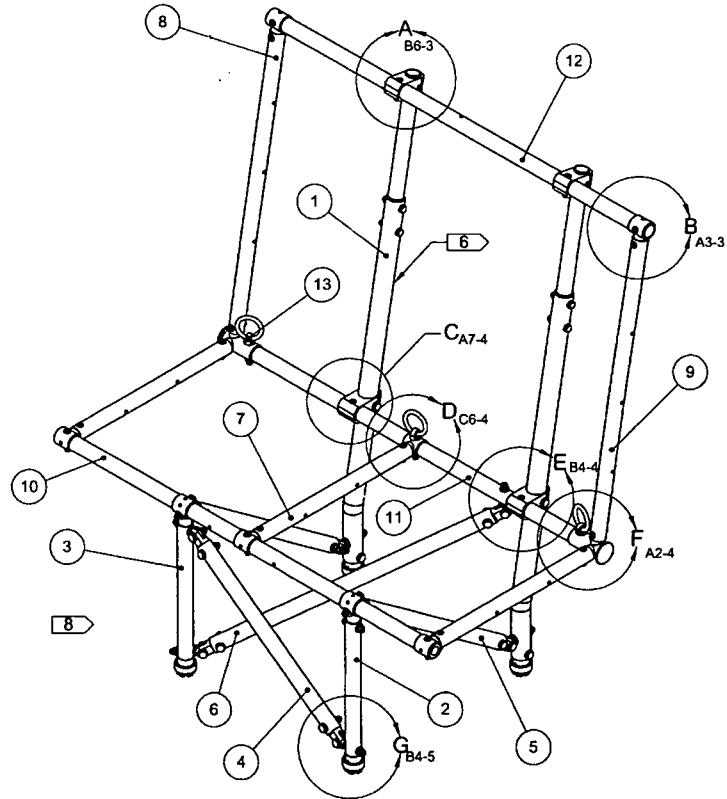
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
08.07.09
100

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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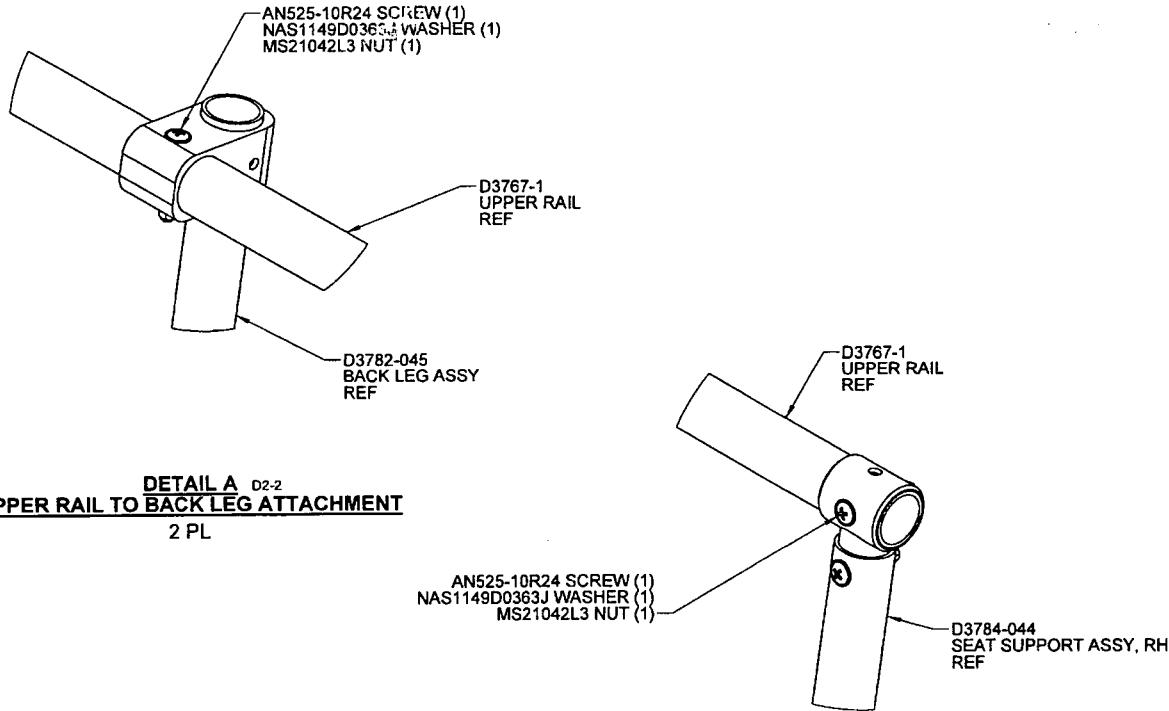
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S4292

RELEASED
08-07-09

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. B
MFG. APPR.	MP	D412-769-1	SHEET 3 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	AFT FACING SEAT ASSY, LH	NTS
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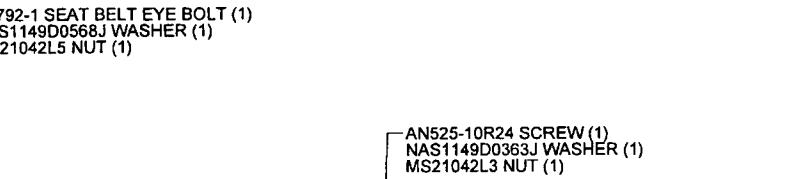
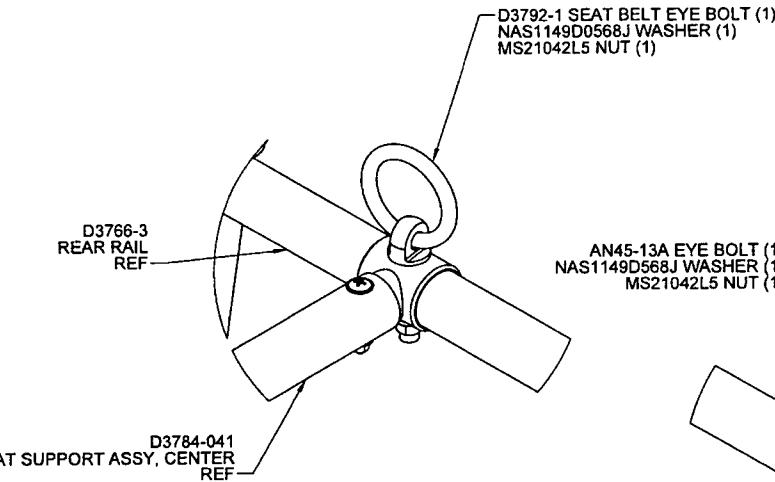
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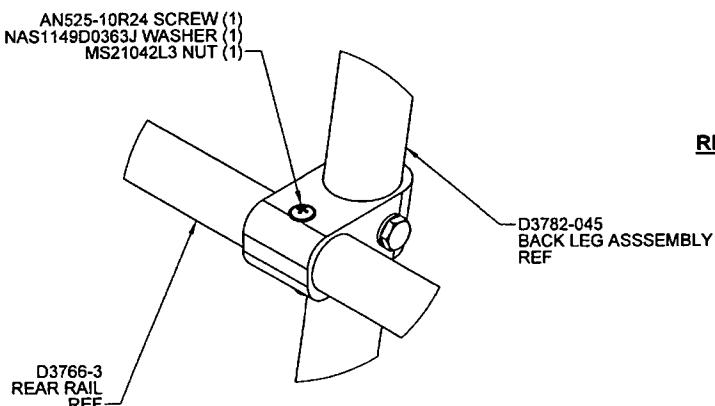
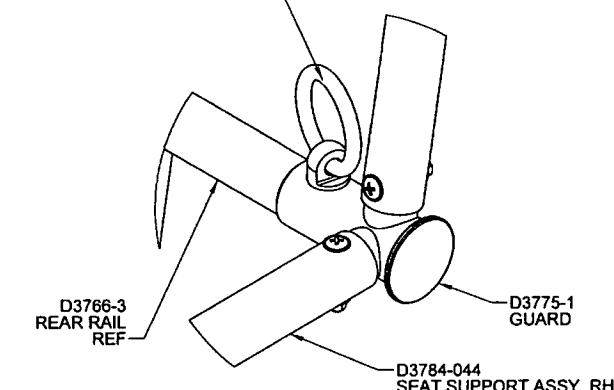
C

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D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)



DETAIL C C₂₋₂
REAR RAIL TO BACK LEG ATTACHMENT

DETAIL E C₁₋₂
REAR RAIL TO BACK LEG ATTACHMENT

DETAIL F B₁₋₂
SEAT SUPPORT ATTACHMENT
2 PL

RELEASE
08.06.2014

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	PB	DRAWING NO.
MFG. APPR.	AP	REV. B
APPROVED	AP	D412-769-1
DE APPR.	AP	SHEET 4 OF 7
DATE	08.06.25	TITLE AFT FACING SEAT ASSY, LH SCALE NTS

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NOTE: Date & initial all entries

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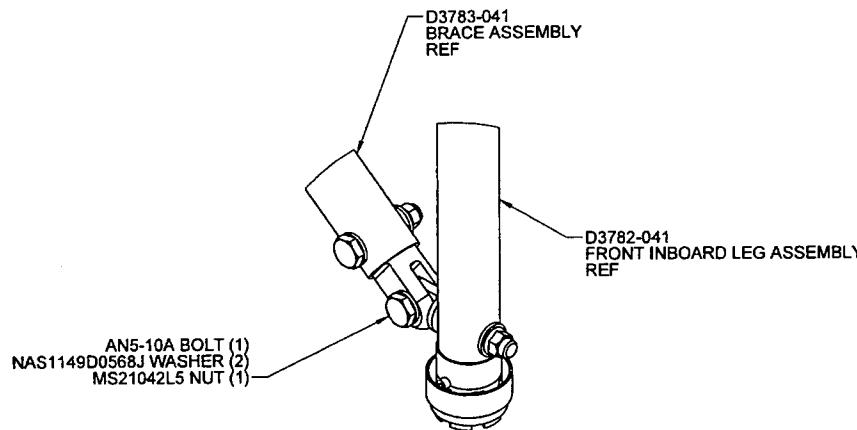
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DETAIL G_{B2-2}
BRACE ATTACHMENT

6 PL

54292

RELEASED
09-07-07 MA

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DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AS</i>	D412-769-1	SHEET 5 OF 7
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	AFT FACING SEAT ASSY, LH	
DATE	08.06.25	NTS	

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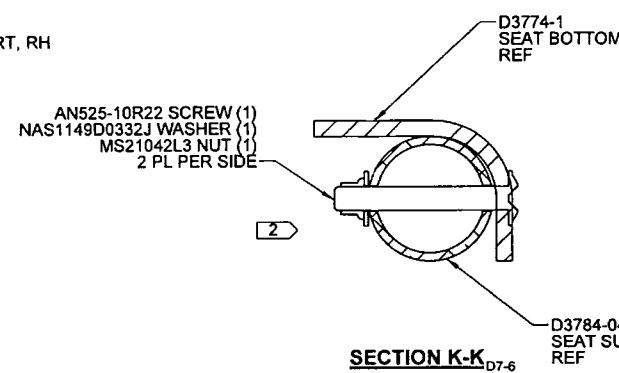
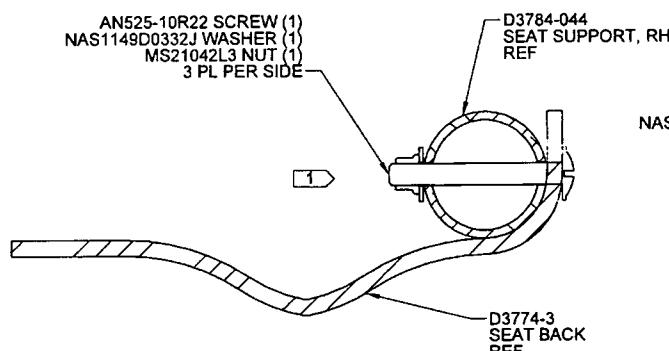
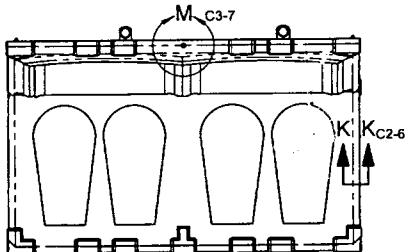
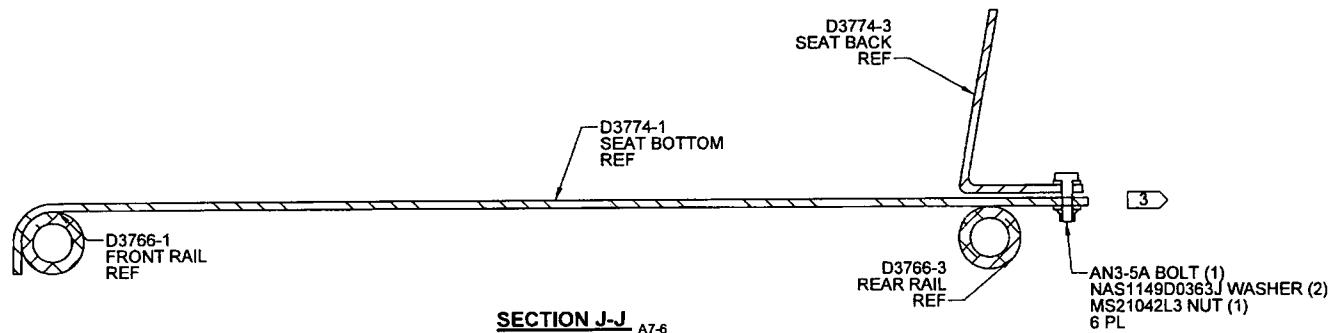
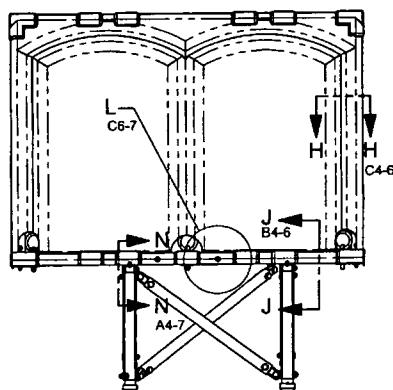
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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SECTION H-H B7-6RELEASER
08-07-03 100

S4292

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO.
MFG. APPR.	<i>NY</i>	D412-769-1
APPROVED	<i>NY</i>	REV. B
DE APPR.	<i>NY</i>	SCALE
DATE	08.06.25	AFT FACING SEAT ASSY, LH

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NOTES:
 1) TRANSFER DRILL Ø0.201 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
 2) TRANSFER DRILL Ø0.201 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
 3) TRANSFER DRILL Ø0.201 FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

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W/O:		WORK ORDER CHANGES					
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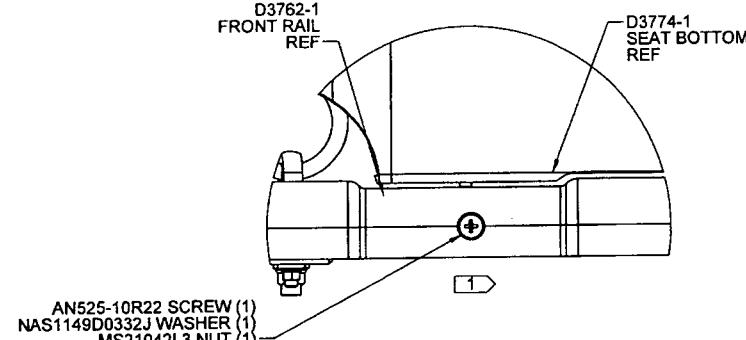
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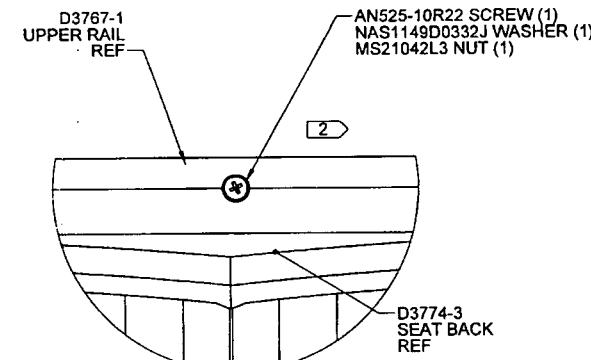
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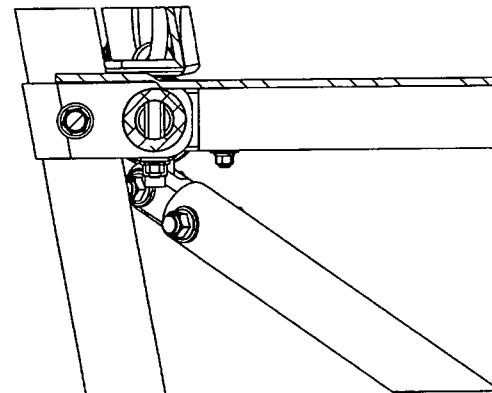
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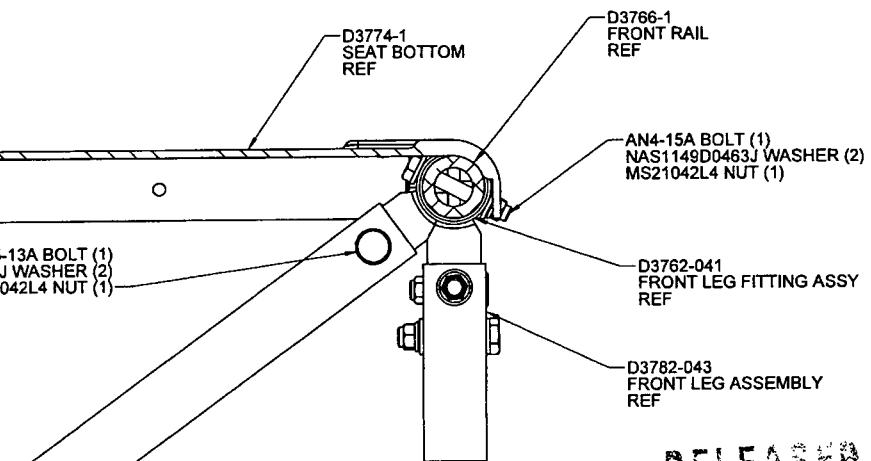
DETAIL A7-8
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M07-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL



RELEASER
08-07-02 11:00
54292

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. B
MFG. APPR.	✓	D412-769-1	SHEET 7 OF 7
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	AFT FACING SEAT ASSY, LH	NTS
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NOTES:

- 1) TRANSFER DRILL Ø0.201 FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
- 2) TRANSFER DRILL Ø0.201 FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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